

ABSTRACT

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A method for brazing aluminum alloy-assembled articles with a filler alloy having a liquidus temperature of 540°C or lower and a difference of temperature between the liquidus temperature and the solidus temperature being 100°C or lower, wherein the highest temperature reached in the assembled article at the time of heating for brazing being set 40°C or more higher than the liquidus temperature but 585°C or lower. An aluminum alloy-filler alloy usable at low temperature for brazing, which comprises Si in an amount of 4.0 wt% to 8.0 wt%, Zn in an amount of 7.0 wt% to 20.0 wt% and Cu in an amount of 10.0 wt % to 35.0 wt%, with the balance being made of aluminum.